





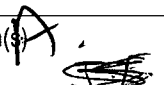





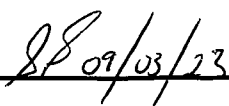



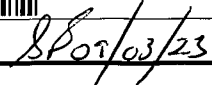


Date: Monday, 16/03/2009 2:00:57 PM
 User: Julie Dawson

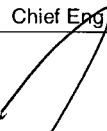
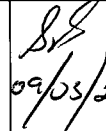

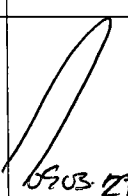

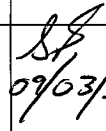

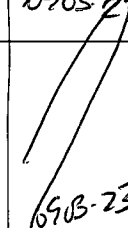

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 46516		
Estimate Number	: 10256		
P.O. Number	:	Part Number	: D22303
This Issue	: 16/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2230 REV F
First Issue	: / /	Project Number	: N/A
Previous Run	: 45915	Drawing Revision	: F
Written By	:	Material	:
Checked & Approved By	: <u>JUD 09.03.16</u>	Due Date	: 03/04/2009
Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
			
Comment: Qty.: 0.0717 f(s)/Unit Total: 11.4744 f(s) Lug Extrusion D2423 Batch: <u>B45800</u> J.F. 09/03/22 			
2.0	D22303P	LUG	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 160.0000 Each(s) LUG 			
3.0	BAND SAW	BAND SAW	
			
Comment: Band Saw Cut D2423 extrusion to 0.82" Batch: <u>B45800</u> J.F. 09/03/22 			
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2230-3 Check for crack while loading into the machine. N.A 09/03/24  			
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE N.A 09/03/24 			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2230-3 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 09/04/06

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46516</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/23	4.0	First part thickness dimension was too thin .750 \pm .010 was .633. R.C. Bad origin, operator error		Scrap & replace qty 1 B <u>45800</u>	 09/03/23	J.F. 09/03/23		
		One part is under size dimension of .750 \pm .010 R.C. Blank material was cut crooked in 5 axis.		- Replace B <u>45800</u> - Scrap. Revise blank cut size on Seq. 3.0	 09/03/23	J.F. 09/04/06		
09/03/24	4.0	1 part scrap because Blank was cut too thin		<u>Q-1/9 of .06</u>	N.A 09/03/24	J.F. 09/04/06		

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 2:00:57 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 46516

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/03/27

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

EL 09/03/30

167

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EL 09-03-30

167

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

15:35

OVEN TEMPERATURE:

300°

FINISH TIME:

16:05

cmo/ EL

09/03/30

x167

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

EL 09-03-31

167

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST476

SS 09/04/01

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/02

mf 09-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

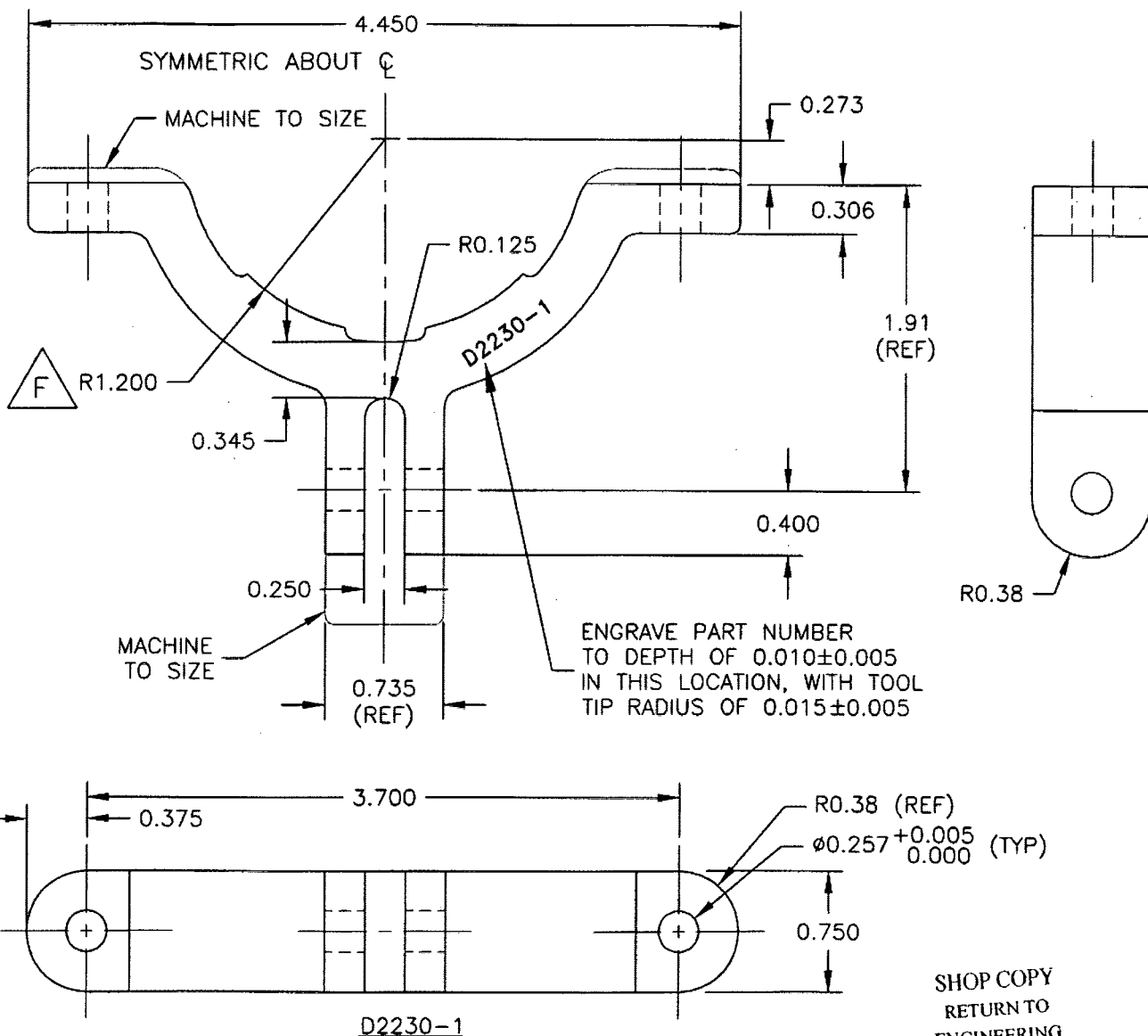
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
CHECKED	JP	APPROVED	JP	DRAWING NO. D2230	SHEET 1 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE	1:1
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			

RELEASED
99.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

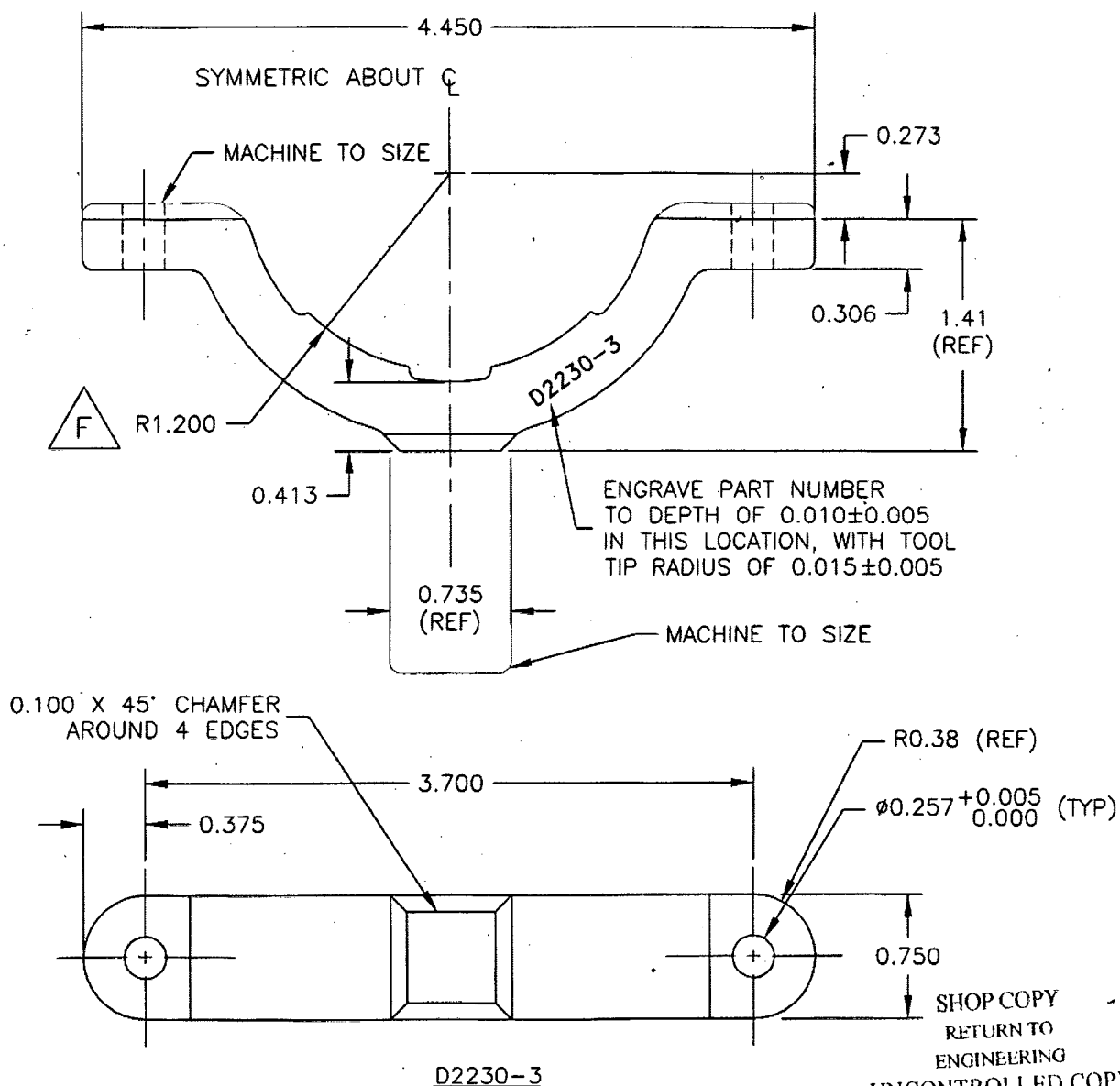
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 40516



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. *Huslo*